

Ship Aug 30

Date: Tuesday, 2/28/2006 9:29:05 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 25961	
Estimate Number : 11527	
P.O. Number : <i>NA</i>	Part Number : D3021041
This Issue : 2/28/2006 S.O. No. : <i>NA</i>	Drawing Number : D3021 / D3017
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/27/2006 Type : LARGE FAB ASSY	Drawing Revision : A/A
Previous Run : 25794	Material : <i>NA</i>
Written By. : <i>NA</i>	Due Date : 3/30/2006 Qty: 1 Um: Each
Checked & Approved By : <i>NA 06.02.28</i>	
Comment : Est. 01.10.22 New Issue SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
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Comment: Qty.: 2.1875 f(s)/Unit Total : 2.1875 f(s)
4130 Tube .750 OD x.049W

Cut: AISI 4130N tube, Ø3/4" x 0.049" wall batch: *M100843*

07/08/13

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D3021-041T1

3--Deburr

07/08/13

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

PD 07-08-15

4.0	M4130NS049	4130 Sheet .049 wall
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Comment: Qty.: 1.0500 sf(s)/Unit Total : 1.0500 sf(s)
4130 Sheet .049 wall

Cut: AISI 4130N sheet, 18 gauge (0.050 thick)

batch: *M11612*

Identify For D3017-11 Cap

07/08/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/08/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 25961

Part Number: D3021041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut end caps as per Dwg D3017

2-Weld as per Dwg D3021

A/R Steel Rod Batch: ~~1115~~ M15684

K 07/08/15

6.0

QC/9

WELD INSPECTION



Comment: VISUAL WELDING INSPECTION

Inspect Level 9

Inspect for foreign objects per QSI 024

PD 07-08-15

7.0

POWDER COATING

POWDER COATING



M10484



(1K)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-k 07/08/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 07/08/27

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m 07/08/27

10.0

DC

DOCUMENT CONTROL



(1)

Comment: DOCUMENT CONTROL

Inspection Level 21

D 07/08/29

Job Completion



u 07-08-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART

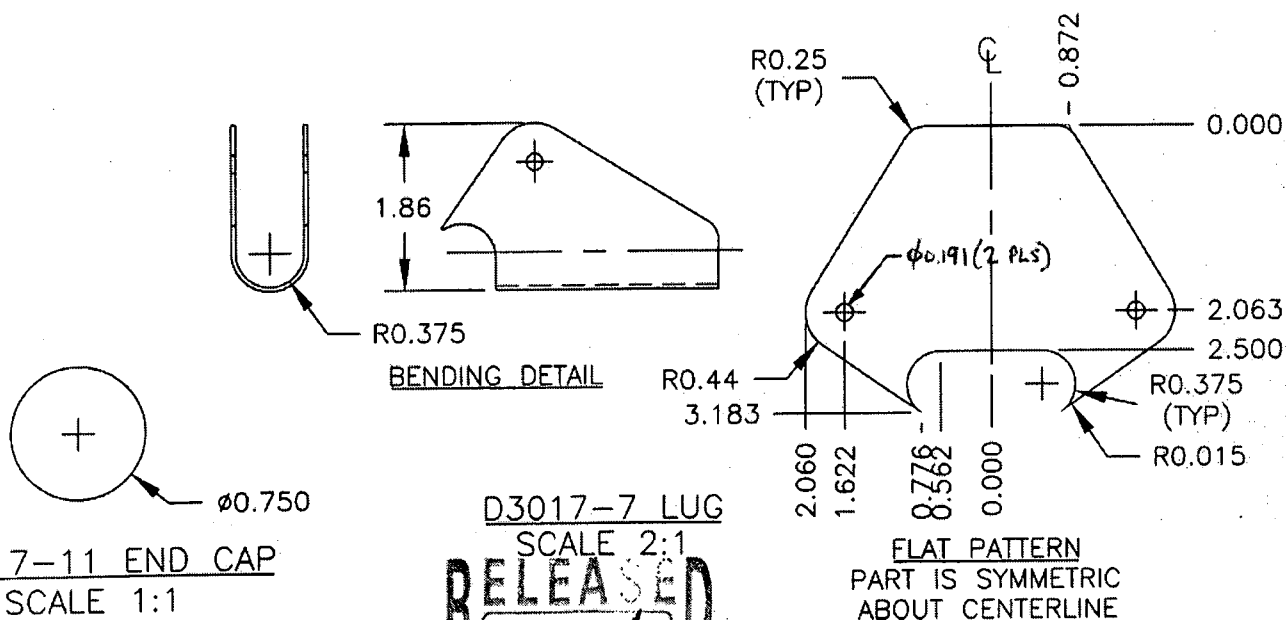
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

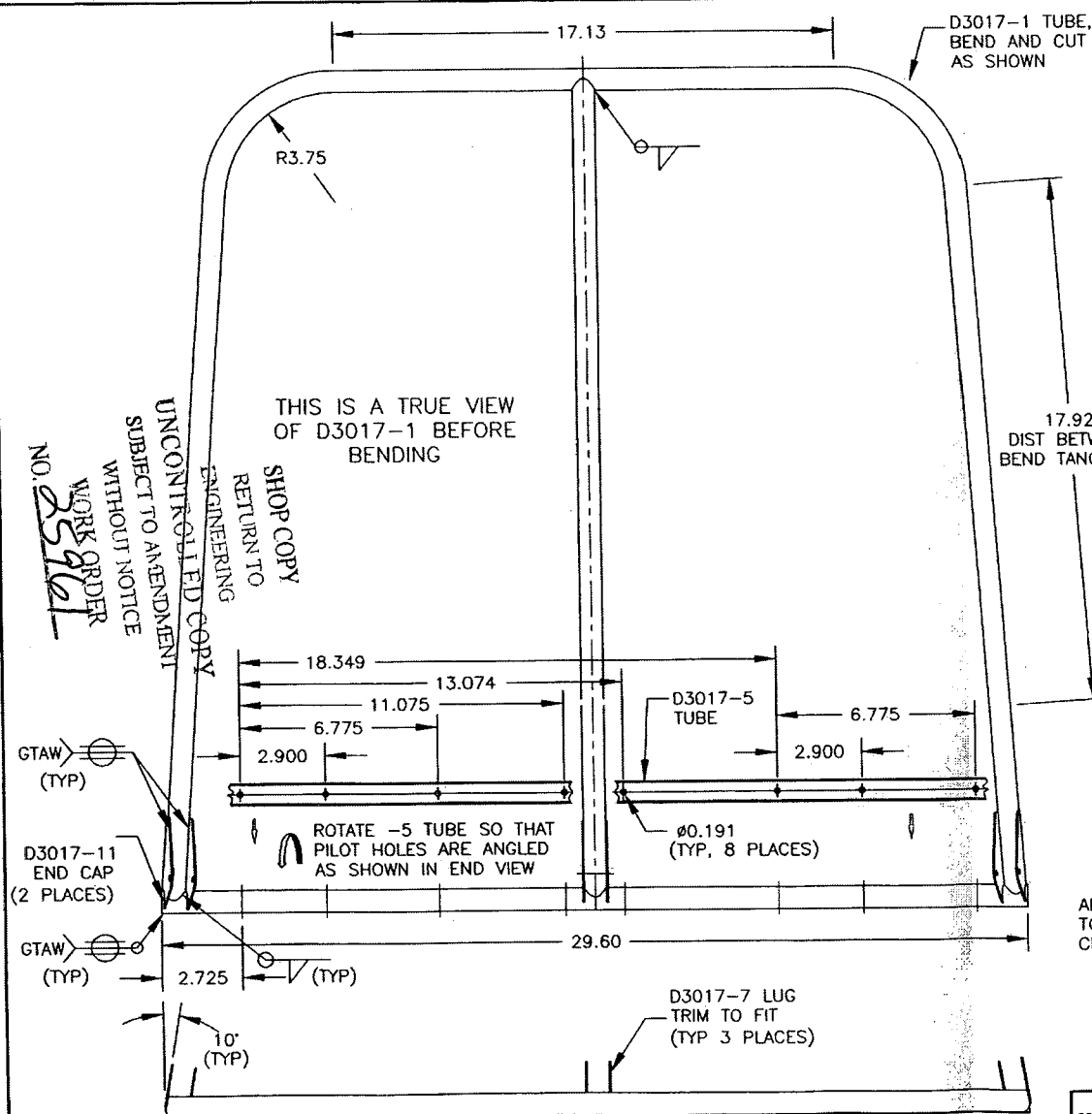
- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25961



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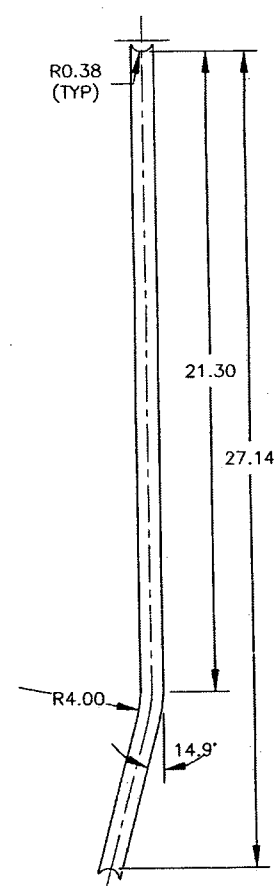
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D3017-1 TUBE,
BEND AND CUT
AS SHOWN

DRILL 0.128 HOLES TO LINE UP
WITH D3023-1 BACK PANEL

26.2°
ANGLE
TO HOLE
CENTERLINE



D3017-3 TUBE

RELEASED
01-06-07

D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

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DATE 01.05.18		TITLE BACK FRAME ASSEMBLY				SCALE 1:4	